

5289280



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5795-15

Job Sheet 207415



NO 20.02.20

POSITIVE
RECALL

Part No: D5795-15

Job Qty: 24 pcs

Part Name: Placard Bracket



Part Weight: 0 lbs

Job Created: 2/25/20

Due Date: 3/6/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

POSITIVE RECALL

EFFECTIVE AUTH

RELEASED DATE

Priority: Medium

Placed by mistake
NO 20.02.20

Note: URF 20-522 DWG D5795 Rev.A IPP Rev. A 2020.01.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	24 pcs	3/6/20	3/6/20	0.17 2.00	Waterjet - Flow		dc 20/02/20
110	QC 2	24 pcs	3/6/20	3/6/20	0.00 0.00	QC 2 - 1		
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		dc 20/02/20
						QC 2 - 32		
						QC 2 - 33		
						QC 2 - 35		
						QC 2 - 39		
						QC 2 - 4		
						QC 2 - 40		
						QC 2 - 44		
						QC 2 - 45		
						QC 2 - 48		
						QC 2 - 49		
						QC 2 - 50		
						QC 2 - 51		
						QC 2 - 52		
						QC 2 - 57		
						QC 2 - 62		
						QC 2 - 63		
						QC 2 - 8		
						QC 2 - 66		
						QC 2 - 64		
						QC 2 - 65		

PRIORITY

120 QC 8	24 pcs	3/6/20	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 89	
				QC 2 - 76	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	24 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
140 QC 21 - SA	24 pcs	3/6/20	0.00 0.00	Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

FEB 28 2020
DAS
10:09

MAC

FEB 28 2020

Part Op **100** - 1-Cut as per DWG. D5795-15 DWG. Rev: A PROG. Rev: A 2-Deburr if necessaryDescriptions: **110** - QC2- Inspect parts off machine FAI/FAIB**120** - QC8- Inspect parts - second check**130** - Identify as per dwg & Stock Location: _____**140** - QC21- Final Inspection - Work Order Release**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
M1010S20GA	1010/1025 Sheet	1.4400 sf (.06 ea)	100-Waterjet - Flow - 1	FM3805

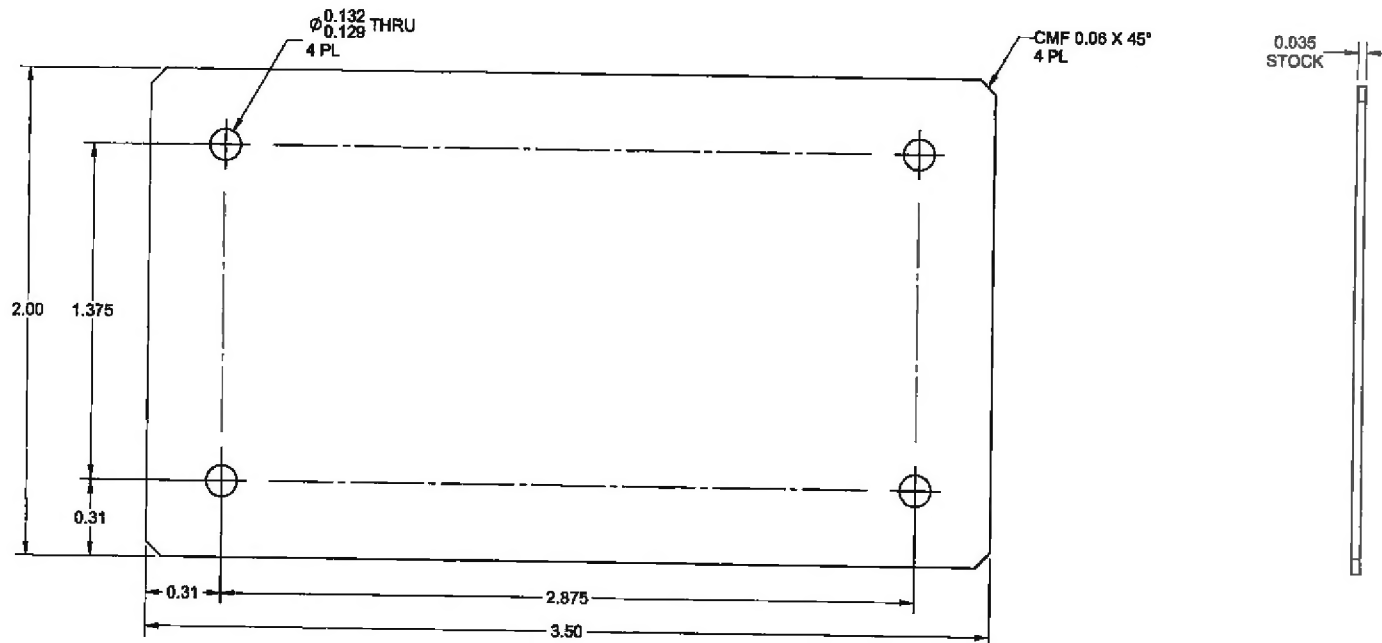
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M1010S20GA	1	79	0

Part Specifications

Specifications could not be found.

Plex 2/26/20 10:04 AM Dart.lajeunesse.marie



D5785-15 PLACARD BRACKET
(DERIVED FROM AERO DESIGN P/N 36204-10)

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 1010/1025 STEEL SHEET, COLD ROLLED, #20GA (0.035 THICK)
PER ASTM A36/A368/A1008 OR CSA G40-21 38W/44W/50W/60W/70W
REF DART SPEC M1010-S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

RELEASED
2020 FEB 18 No

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5795	SHEET 5 OF 8
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	41 SHORT LID ASSY	NTS
DATE	20.01.15	COPYRIGHT © 2020 BY DART AEROSPACE LTD	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207415
MW
20-02-26



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26359**

Purchase Order Date 11/3/2014

PO Print Date 11/3/2014

Page Number 1 of 2

Order From :
CAMPI STEEL
935 BOUL DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

VC-CAM002

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 800 667 4248

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

13505

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	M1010S20GA	1010/1025 SHEET	11/3/2014 Yes 11/3/2014		160.00 sf	\$1.15	\$184.68
MATERIAL AS PER AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 35W/45W/50W/60W/70W MINIMUM YIELD TENSILE STRENGTH= 28KSI MINIMUM ULTIMATE TENSILE STRENGTH= 42KSI COLD ROLL							

Line Total: \$184.68

2	71401-15	PROCUREMENT QUALITY CLAUSES	11/3/2014 No 11/3/2014		1.00	\$0.00	\$0.00
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Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality document

804-11-6

Note:

11/3/2014



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
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Page Number 2 of 2

Order From :

VC-CAM002

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 800 667 4248

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-3607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Chantal Lavoie

Line Total: \$0.00

PO Total: \$184.68

u CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

1

Change Date:

11/3/2014



810-432-5780

UNIT DEREGULATED LTD
1070 GREENHILL STREET
BURNBURY,
ONTARIO
R6B 1H7

Merci! - Thank you!

Tél.: 450 377-4248
Fax : 450 377-5696

Tél.: 1 800 667-4248
Fax : 1 866 456-4242

DISTRIBUTEUR D'ACIER ET DE METAUX SPECIALIS
STEEL AND SPECIALTY METALS INC. TORONTO

www.aciercampi.com

EXPÉDIEZ À / SHIP TO :

1501 KENNEDY LTD.
1278 ABERDEEN STREET
HAMILTON,
ONTARIO
K6G 1K7

EXPEDITION ORDER	N°	040114
DATE	04/11/14	
BON DE LIVRAISON PACKING SLIP	N°	040114
DATE DE LIVRAISON DELIVERY DATE	04/11/14	

VOLUME N° DE COMMANDE / YOUR P.O. N°	VEN'D./SALES M.	CODE CLIENT / CUST. CODE	EXPEDIER PAR / SHIP VIA	TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
000000	7	8659	BY AIR	NET-30 DAYS	00		01

[illegible]

SP/4-11-6.

* Unités de mesure : CLB Cn 1000 g/l, CPI Cn 1000 g/l, UN Cn 1000 g/l, PI Pn 1000 g/l, PC Pn 1000 g/l

POIDS TOTAL
TOTAL WEIGHT

[illegible][illegible]

SOUS-TOTAL
SUB TOTAL
T.P.S.
G.S.T.
T.V.Q. / T.V.H.
G.S.T. / H.S.T.
TOTAL

PREPARE PAR / PREPARED BY	VERIFIE PAR / VERIFIED BY	DATE PAR / DOCUMENT BY	RECEIVED DATE
---------------------------	---------------------------	------------------------	---------------

1. ☐ MERCHANDISE RECEIVED IN POOR CONDITION. ☒ MERCHANDISE RECEIVED IN GOOD CONDITION.

SIGNATURE DU CLIENT / CUSTOMER : SIGNATURE

DATE _____

508 170-10

RECU LE 16 AOUT 2014

34

01183
FEC-4820G

SO No, Item & Date: 8010095 090014 2013/04/11	Shipment No. & Date: 1000041193 2013/04/12	TC No., Date & Time: ESA-64470 2013/04/12 - 15:23:13													
Sold to Customer Name and Address:	Ship to Customer Name and Address:	Customer PO NO. Item: 734194/1													
		BOL NO.: 1000041193													
		Cust. Part No.: TAD91831													
		Carrier: TRIPLE K TRANSPORT LTD - 32000/33000 (240													
Customer Specification: CR STEEL SHEET Carbon CQ/CS ASTM A1008 CS TY B (2012) Batch Annealed Top Standard Surface Standard Shape Pickled Oiled Light Matte Finish Edges Sealant Required Std Thickness Tol															
Supplementary Instructions: Test Cert Jean-francois.girard@ryerson.com															
Insap TTR: Chemical Analysis		Cust Use: RESALE													
ESSAR STEEL ALGOAIA INC. HEREBY CERTIFIES THAT THE MATERIAL HEREIN DESCRIBED WAS MADE AND TESTED IN ACCORDANCE WITH THE RULES OF THE SPECIFICATION SHOWN. ALL RESULTS ARE RETAINED IN ACCORDANCE WITH THE COMPANY'S STANDARD RECORD KEEPING PRACTICES. THIS ILL TEST REPORT MAY NOT BE REPRODUCED EXCEPT IN FULL WITHOUT WRITTEN APPROVAL OF ESSAR STEEL ALGOAIA INC. IF YOU RECEIVE THIS DOCUMENT AND ARE NOT THE INTENDED RECEIVER, PLEASE CALL (705) 945-4095 FOR INSTRUCTIONS ON METHOD OF DISPOSAL OF DOCUMENT.															
MEETS EN 10204 3.1															
ISO QUALITY AND ENVIRONMENTAL CERTIFICATES AVAILABLE AT WWW.ESSARSTEELALGOAIA.COM															
ALL HEATS FULLY KILLED															
HEATS INDICATED WITH (C) FINE GRAINED															
HEATS INDICATED WITH (H) MADE IN CANADA WITH DOMESTIC AND NORTH AMERICAN MATERIALS.															
Dimensions (L x W x T)	Batch No.	Heat No. HES													
0.0347" x 48.060"	TAD91831	2183PS-01													
	Quantity	Pcs													
	45,170 LB	1													
CHEMICAL PROPERTIES															
Heat No. (wt%)	C	Mn	P	S	Si	Cr	Ni	Cu	Mo	Al	Nb	V	B	Ti	N
2183PS	0.05	0.18	0.012	0.006	0.020	0.03	0.02	0.04	0.00	0.030	0.000	0.000	0.0000	0.001	0.0033

ACTIER CAMPRI INC. P.O. - 61183 S.O. - 336233

K. UGRADPAGA
MANAGER METALLURGICAL SERVICES

WARNING: THE TEST RESULTS AND VALUES REPORTED HEREIN INDICATE ONLY THAT (1) THE PARTICULAR STEEL FOR WHICH THIS CERTIFICATE IS ISSUED (2) TESTS TO DETERMINE SPECIFIED YIELD STRENGTH AND (3) THE ANALYSIS AND PHYSICAL PROPERTIES OF SUCH STEEL ARE IN COMPLIANCE WITH THE REQUIREMENTS OF THE SPECIFICATION INDICATED. THE RESULTS OR VALUES REPORTED HEREIN CAN NOT BE USED TO QUALIFY THIS STEEL FOR ANY SPECIFICATION OTHER THAN THE ONE INDICATED AND CAN NOT BE USED FOR ANY PURPOSE (INCLUDING DESIGN OR CALCULATIONS) AS REPRESENTING THE ACTUAL STRENGTH OF SUCH STEEL.

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: HHS1520GA

DATE: 14.11.67

PO / BATCH NO.: PO24339/M130805

MATERIAL CERT REC'D: 4/2

QUANTITY RECEIVED: 160 SF

QUANTITY INSPECTED: NO. 39

QUANTITY REJECTED: 2

THICKNESS ORDERED: 20

THICKNESS RECEIVED: 1.03

SHEET SIZE ORDERED: 41" x 55"

SHEET SIZE RECEIVED: 4 x 8

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL	(Y) N	
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT MATERIAL	(Y) N	
CORRECT REF # TO LINK CERT	(Y) N	H#218303
CORRECT MATERIAL IDENTIFICATION	(Y) N	H1105206A
CORRECT M# ON THE MATERIAL	(Y) N	H130805
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK.				
RECORD RESULTS BELOW				
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D
SIZE OF TEST SAMPLE				
HARDNESS / DUROMETER READING				

testers located in the Quality Office

GC 18 INSPECTION

ENGINEERING SIGNOFF (if required)

INSPECTED BY: _____ SIGNED OFF BY: _____

DATE: 11-11-07 DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					